

Work Order ID 84504

May-15-12 10:36:46 AM

*RUSH*

\*84504\*

Page 1

Item ID: D3670-4-200

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: SPACER

Start Date: 15/05/2012 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan: *ML5*

Date: *12/05/15* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. - Stamp
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Draw Nbr

Revision Nbr

D3670

Rev A

100

0.00

\*100\*

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3670FOLIO REV: *1*

DWG REV: *1*

2-DEBURR AS REQUIRED

*12/5/16*

*102* *✓*

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*12/5/16*

*102* *✓*

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*12.5.16*

*102* *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84504

\*84504\*

Page 2

May-15-12 10:36:46 AM

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Start Date: 15/05/2012 Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Identify as per dwg & Stock Location: LG 0.00

\*130\*

Packaging Memo 0.00

Packaging \*\*\*STOCK IN SKIDTUBE CELL\*\*\*

102 0 BE 12/05/22

140 QC21- Final Inspection - Work Order Release 0.00

\*140\*

QC Memo 0.00

Quality Control

12/15/25 AD  
MCT 12/05/22

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**NOTE:** Date & initial all entries

# Picklist Print

May-15-12 10:44:35 AM

Page 1

Work Order ID: 84504

\*84504\*

Parent Item: D3670-4-200

\*D3670-4-200\*

Parent Item Name: SPACER

Start Date: 15/05/2012

Required Date: 22/05/2012

Start Qty: 100.00

Required Qty: 100.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No				f	80.3360		36.01801			

\*M6061T6T0 3125W 058\*

ALUM TUBE .3125 x .058w

\*\*

52 12/5/16

### Location

### Loc Qty

### Loc Code

MAT013

80.336

116793

1.667

✓ 116939

13.722

117400

13.9

118438

2.584

✓ 119678

23.421

120654

25.042

1.524

3844

12/5/16

\* Could not pull material - inventory wrong

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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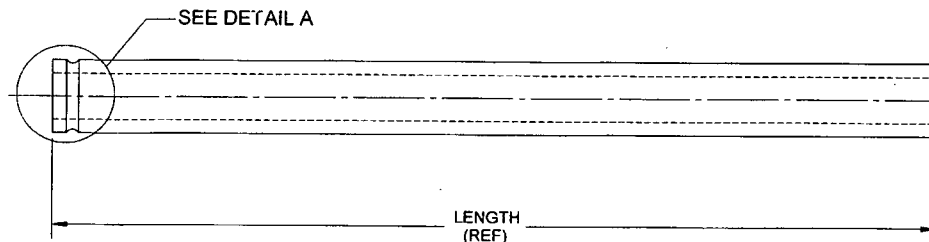
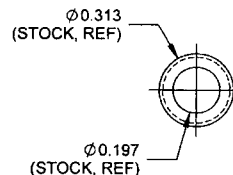
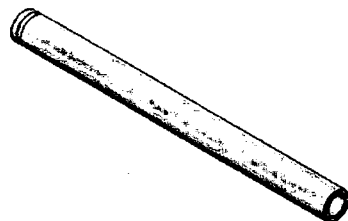
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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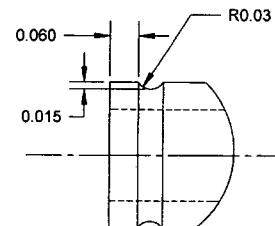
# SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3670-XXXX SPACER

LENGTH

WHERE XXXX IS LENGTH IN INCHES  
EG: 3.750" LONG SPACER: D3670-3750



DETAIL A  
(SCALE 4 : 1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84504 MLJ  
12/05/15

RELEASED  
07.11.06

## NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A	NEW ISSUE	DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D3670	SHEET 1 OF 1
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	SPACER	2:1
DATE	07.10.19	COPY RIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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